

Work Order ID 149605

Thursday, September 15, 2016 9:55:32 AM

149605

Page 1

Item ID: 646.9701

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cutter Sub Assembly

Start Date: 7/20/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 7/25/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: DAS 21 9-88 Date: SEP 15 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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646.9700	REV D2
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SEP 27 2016DAS 6 9-88

110	Pick Kit	0.00
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110

Packaging

Memo

0.00

SEP 27 2016DAS 8 9-88

Packaging

120

0.00

120

Small Fab

Memo

0.32

8x16/10/04 DAS 36 9-88

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note .

A/R RTV LOCTITE 598:

exp. date: 04/18 135497

130

0.00

130

QC

Memo

0.03

8OCT 06 2016 38 9-88

Quality Control

QC5- Inspect part completeness to step on W/O

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: CCKDOT

0.00

140

Packaging

Memo

0.01

Packaging

IDENTIFY AS PER IAW MPP-120

8 10 DAS
6
9-89

OCT 06 2016

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.13

Quality Control

DAS
21
9-89

OCT 11 2016

VS 10/10/07

DAS
21
9-89

OCT 11 2016

DQA: _____ Date: _____



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OTHER : _____																					

Picklist Print

Thursday, September 15, 2016 9:55:37 AM

Page 1

Work Order ID: 149605

149605

Parent Item: 646.9701

646 9701

Parent Item Name: Cutter Sub Assembly

Start Date: 7/20/2016

Required Date: 7/25/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS
:B AS PER REV D 16-03-07 JLM VERIFIED BY:JFS

IPP REV

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9710 *646 9710* Body		Manufactured	No				Each	17.0000		8			
									**				DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				cck012				17					
				142487				15					
				145351				2					
646.9711 *646 9711* Blade		Manufactured	No			110	Each	50.0000	2	16			
									**				DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				CCK106				50					
				147263				50					
MS27039-08-19 *MS27039-08-19* Screw		Purchased	No			110	Each	470.0000	6	48			
									**				DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				GA				1					
				m135046				1					
				ST277				469					
				m135408				69					
				m135536				100					
				m135566				300					

SEP 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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646 9701

Parent Item Name: Cutter Sub Assembly

Start Date: 7/20/2016

Required Date: 7/25/2016

Start Qty: 8.00

Required Qty: 8.00

NAS1149FN832P

Purchased

No

110

Each

3,036.000

12

96

NAS1149FN832P

Washer

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

1537

M133769

89

M135058

1448

ST263

1499

M135603

1499

96

MS21042L08

Purchased

No

110

Each

817.0000

6

48

MS21042L 08

Nut

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

118

m134063

18

m135274

100

ST303

699

m135408

125

m135466

174

m135536

200

m135566

200

48

SEP 27 2016

DQA: _____ Date: _____



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APICAL INDUSTRIES, INC.
dba DART AEROSPACE

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

ENGINEERING CHANGE NOTICE NO.

05360

SHEET 1 OF 1

DWG NO. 646.9700

REV: D

PREPARED BY J. BECKER

DATE: 03/24/16

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: CUTTER SUB ASSY

APPROVED BY:

ENGR *[Signature]*

MFG *[Signature]*

QC *[Signature]*

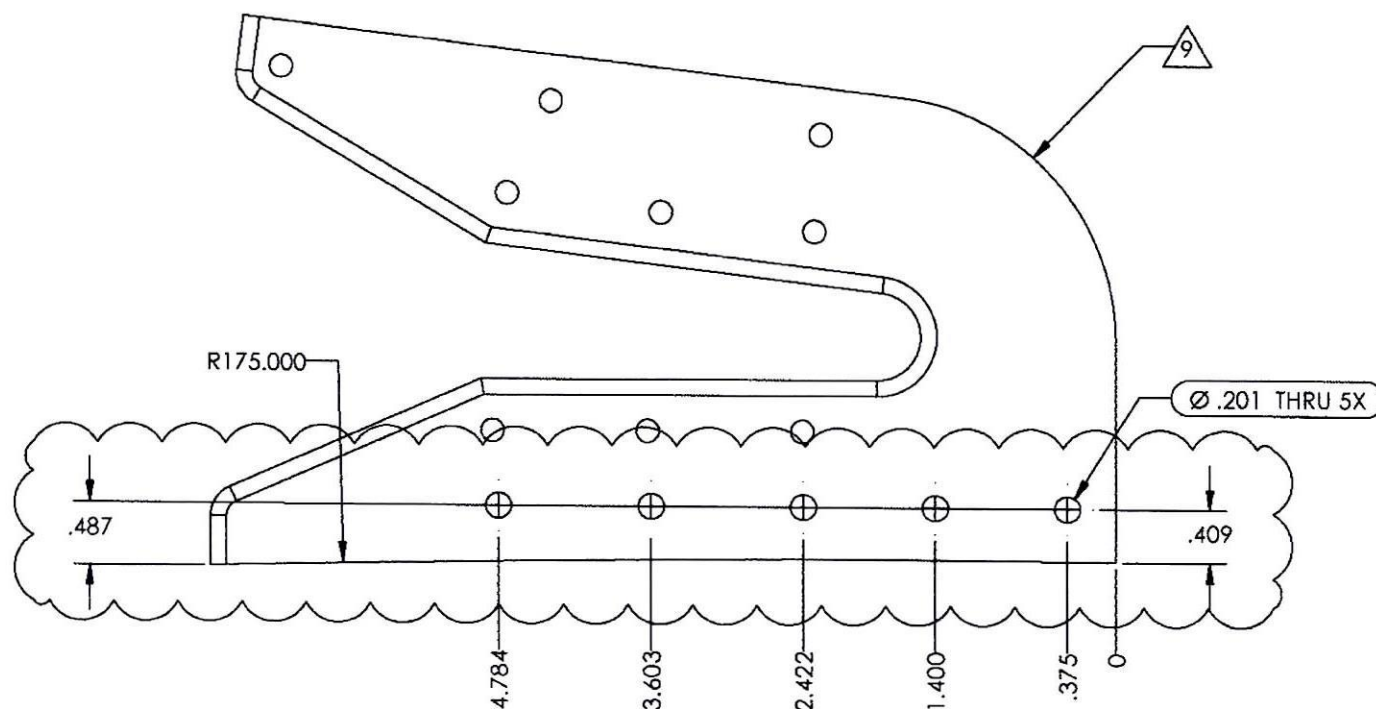
EFF. CURRENT ORDER

REASON: REVISED DIMENSIONS

ECR: N/A

ACTION ITEM:
1.

SHEET 7, ZONE C3 IS:



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 149605 MLJ
1608-03

DOCUMENTS EFFECTED:

☐ PATTERN ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

☐ YES ☒ NO



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO.

05345

SHEET 1 OF 1

DWG NO. 646.9700

REV: D

PREPARED BY J. GARDINER

DATE: 03/15/16

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: CUTTER SUB ASSY

APPROVED BY:

ENGR.

MFG

QC

EFF.

CURRENT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISED NOTES

ECR:

N/A

ACTION ITEM:

1.

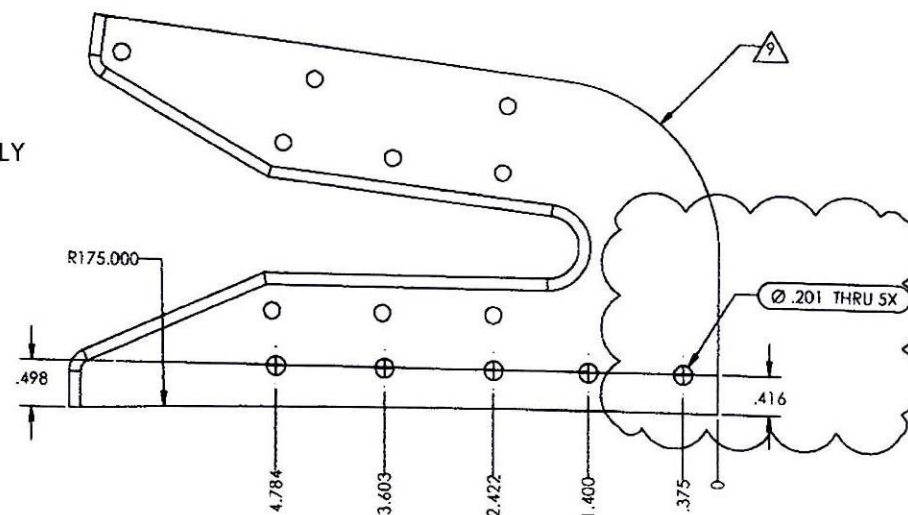
SHEET 1, ZONE A6 IS:

NOTES:

IS

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH IAW MPP-172 SECTION 2.1, 3.3 & 4.3.
- 3 MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MPP-172 SECTION 3.3; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
6. IDENTIFY IAW MPP-120
- 7 APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY
- 8 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
- 9 ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.

SHEET 7, ZONE C5 IS:



DOCUMENTS EFFECTED:

☐ PATTERN ☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

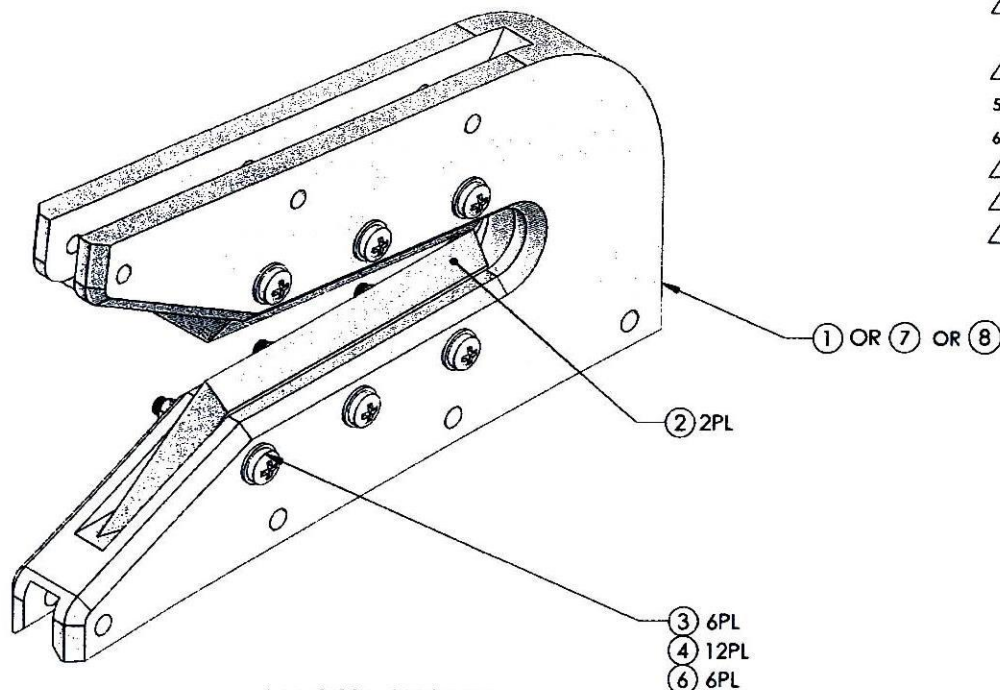
☐ YES ☒ NO

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
	LAST PROPOSED REVISION: PRQ		INC
MC	NEED RELEASE	03/29/81	P. BRAYNO
A	INCORPORATED ECH 0374-4 03088 03972	P. BRAYNO	P. BRAYNO
B	INCORPORATED FCH 02814	07/03/83	P. BRAYNO
C	INCORPORATED ECH 04039	08/09/83	P. BRAYNO
D	INCORPORATED ECH 04329	02/04/84	P. BRAYNO

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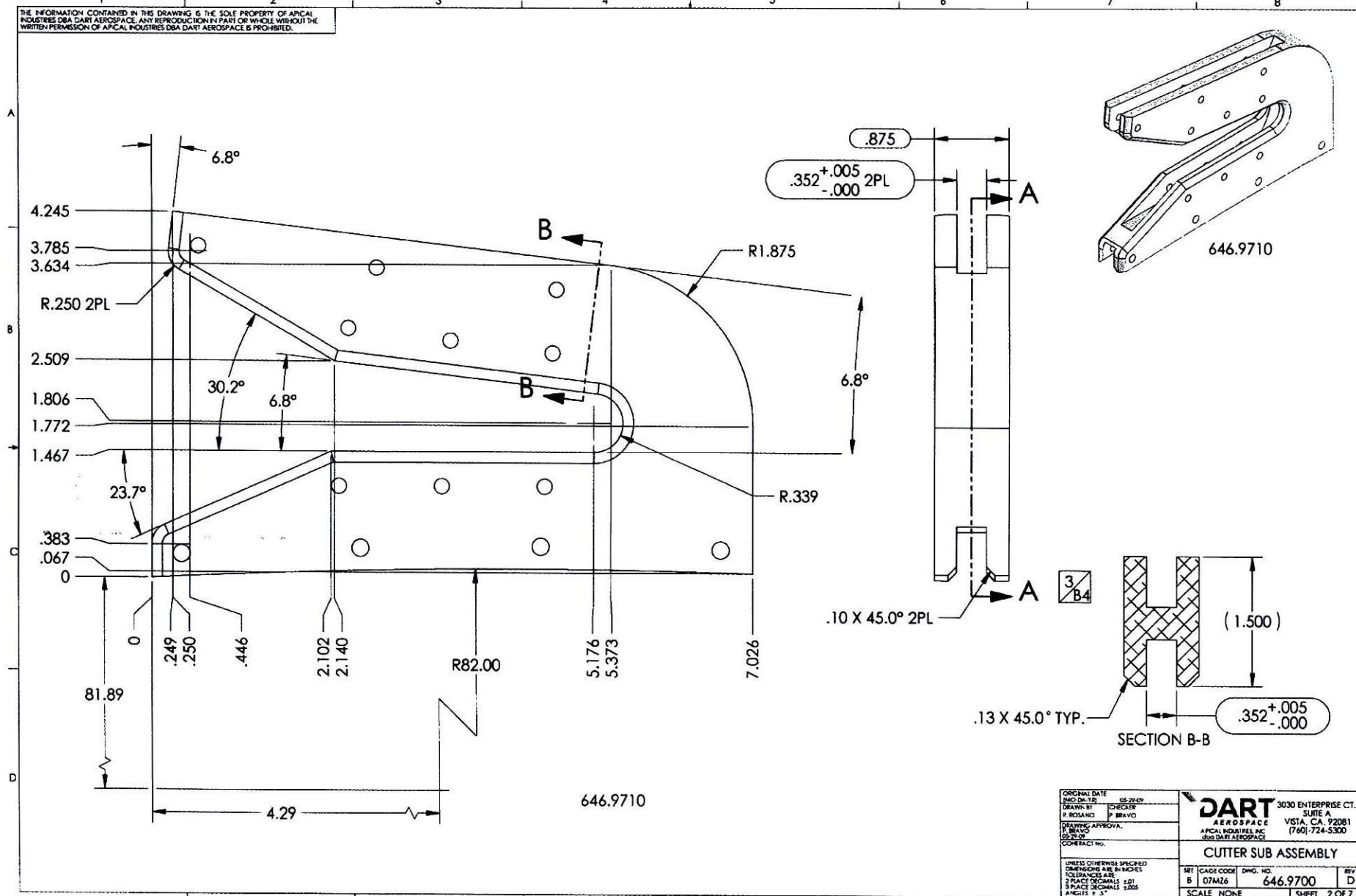
646.9701 SHOWN
646.9702 & 646.9703 TYP

UNINCORPORATED ECN(S)

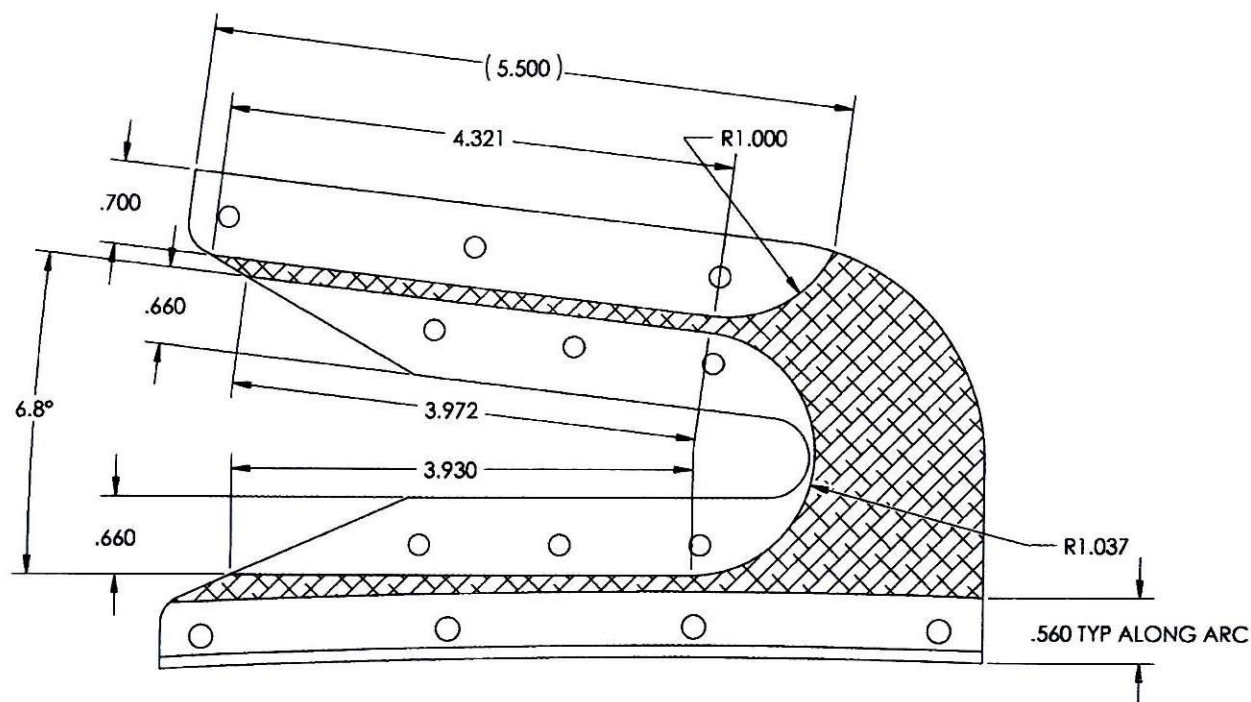
05345, 05360

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6	6	6	6	601.1541	LOCKNLT	MS21047A08															
A/R	A/R	A/R	5	601.2045	RTV, LOCTITE 598																
12	12	12	4	601.2764	WASHER	MS21141F082P															
6	6	6	3	601.2765	SCREW	MS27039-0615P															
2	2	2	2	646.9711	BLADE		△		△												
			1	646.9710	BODY				△												
X				646.9703	CUTTER SUB ASSY																
	X			646.9702	CUTTER SUB ASSY																
		X		646.9701	CUTTER SUB ASSY																
9703	9702	9701	FIND #	PART #	DESCRIPTION		MAT'L		SPEC.												
QTY				PARTS LIST																	
NEXT ASSY (5)				ORDINAL DATE05-75-09 DRAWN BYP. BOGANO DESIGNED BYP. BOGANO APPROVED BYP. BOGANO CONTRACT NO. UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FINISHES: PLATING: PAINT: WELDING: THREADS: FASTENERS: OTHER: 30330 ENTERPRISE C1 SUITE 100 VISTA, CA 92081 (760)-724-5300 APCAI INDUSTRIES INC. 8000 DASH AEROSPACE CUTTER SUB ASSEMBLY <table><tr><td>REV</td><td>CAGE CODE</td><td>QTY</td><td>REV</td></tr><tr><td>B</td><td>07MJA6</td><td>646.9700</td><td>D</td></tr><tr><td colspan="2">SCALE NONE</td><td colspan="2">SHEET 1 OF 2</td></tr></table>						REV	CAGE CODE	QTY	REV	B	07MJA6	646.9700	D	SCALE NONE		SHEET 1 OF 2	
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B	07MJA6	646.9700	D																		
SCALE NONE		SHEET 1 OF 2																			
646.9600																					

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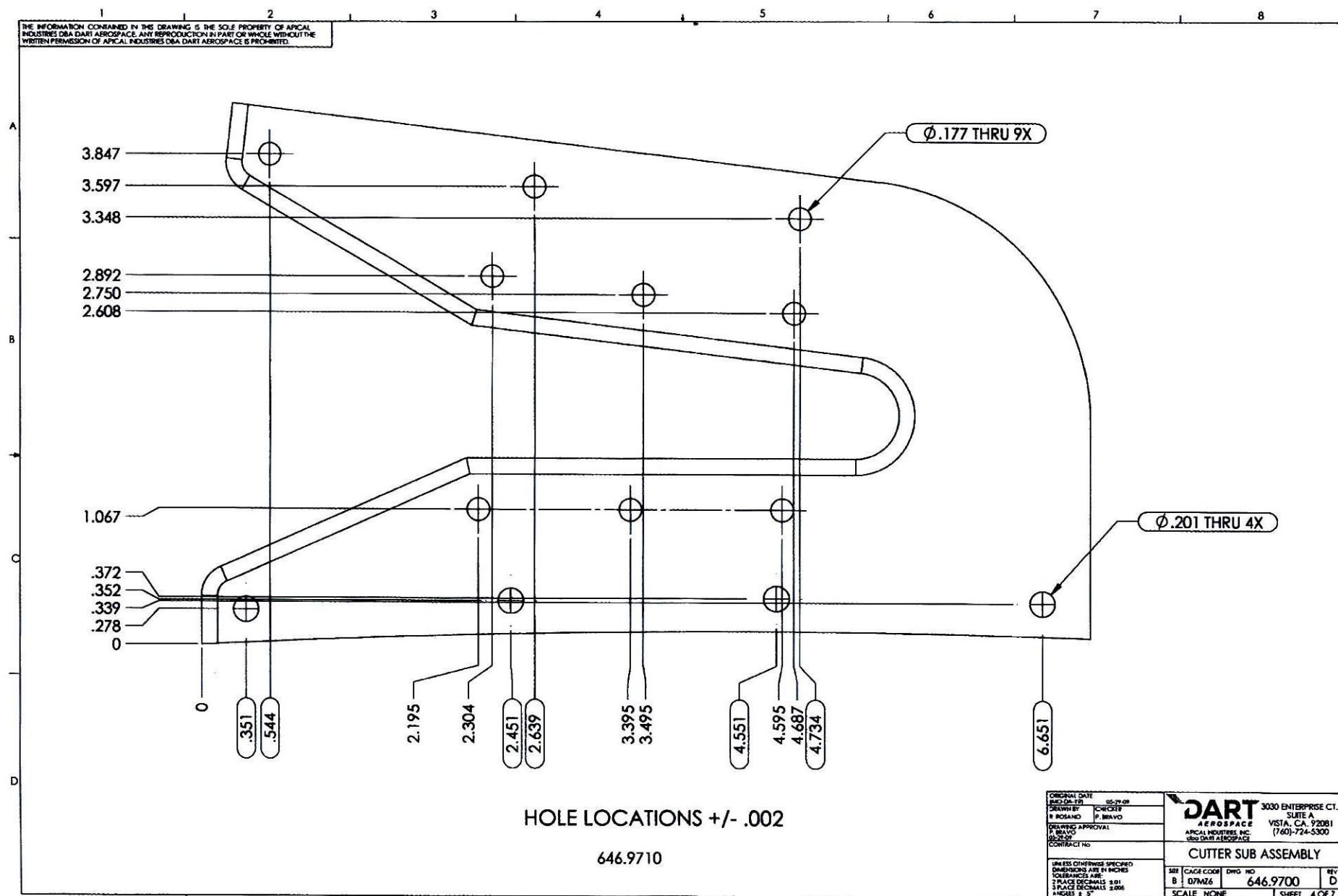


SECTION A-A $\frac{2}{C6}$

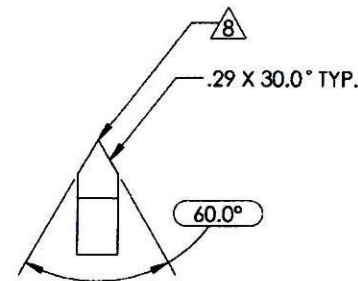
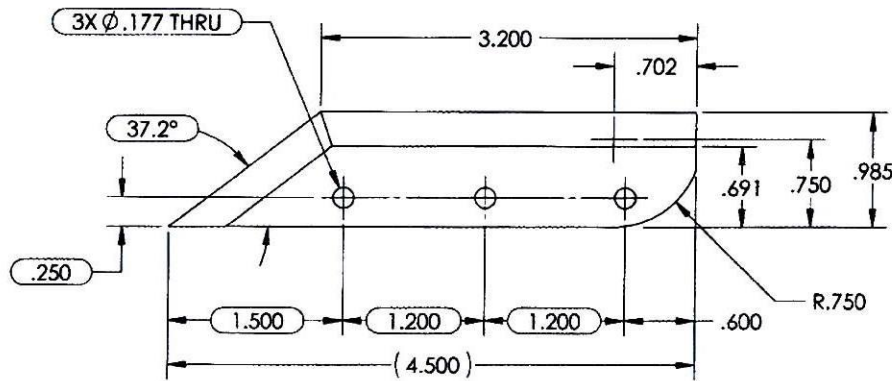
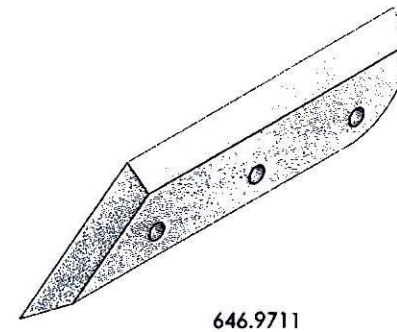
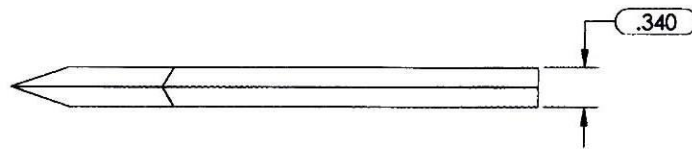
646.9710

ORIGINAL DATE 04/29/09		3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760)-724-5300	
DRAWN BY E. ROSANO	CHECKED P. BRAVO	DART AEROSPACE APICAL INDUSTRIES INC. DBA DART AEROSPACE	
DRAWING APPROVAL P. BRAVO DATE CONTRACT NO.		CUITER SUB ASSEMBLY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ± .01 2 PLACE DECIMALS ± .005 ANGLES ± .5°		REV B	REV D
SCALE NONE	CAGE CODE 07MZ6	DWG. NO. 646.9700	SHEET 3 OF 7

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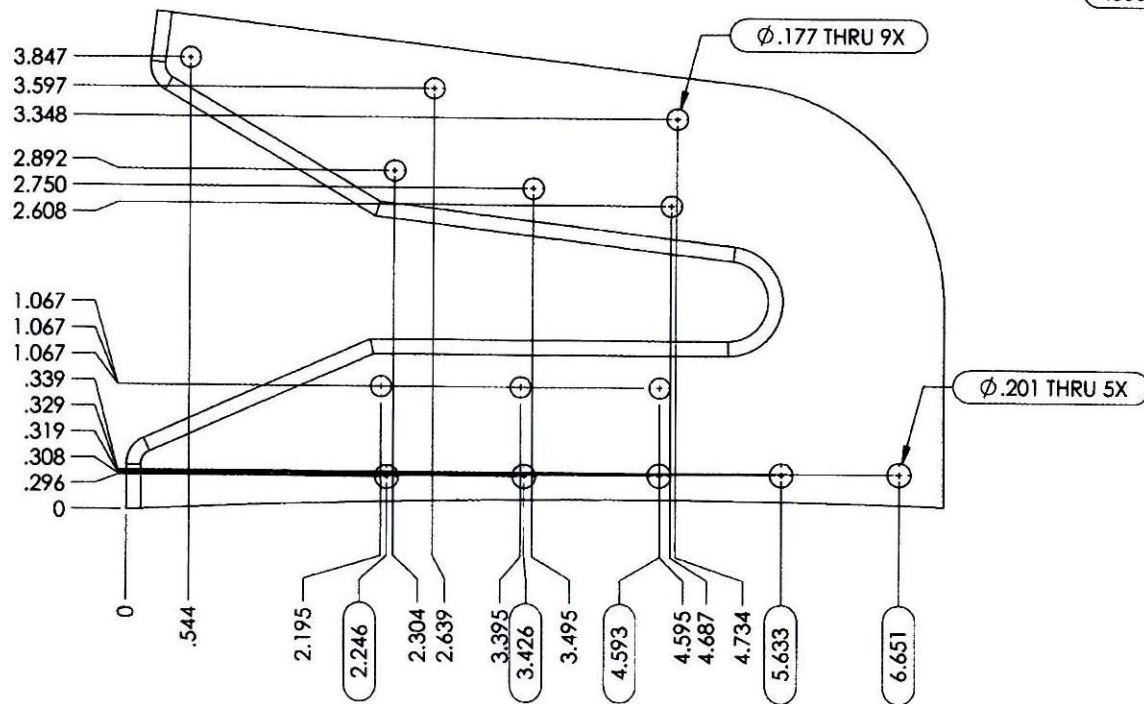
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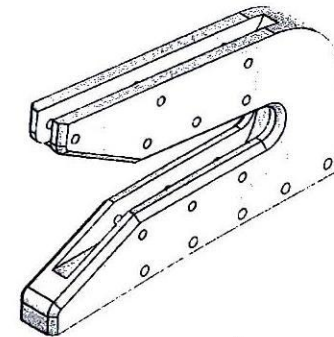
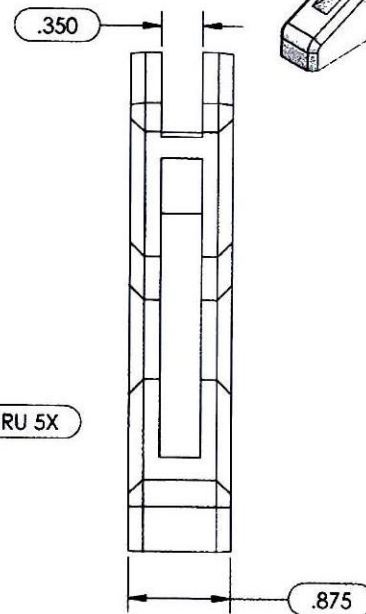
646.9711

ORIGINAL DATE: 10-03-78		CUTTER	
DRAWN BY: P. ROSANO	CHECKED: P. BRAVO	3030 ENTERPRISE CT., SUITE A, VISTA, CA. 92081	
DRAWING APPROVAL: P. BRAVO		APICAL INDUSTRIES INC. (760) 724-5300	
DATE: 10-03-78		CUTTER SUB ASSEMBLY	
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. 10 INCHES = 1.00. 2 PLACE DECIMALS = .01. 3 PLACE DECIMALS = .001. ANGLES: 1/2°		SIZE: 8	REV: D
CAGE CODE: 07M26	DWG. NO.: 646.9700	SCALE: NONE	
SHEET: 5 OF 7			

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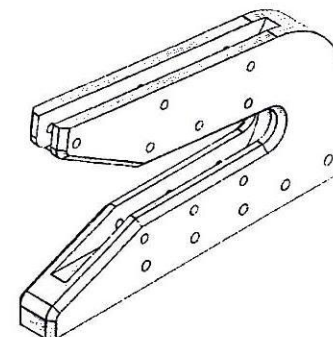
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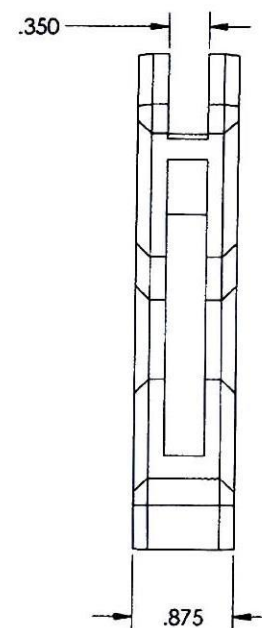
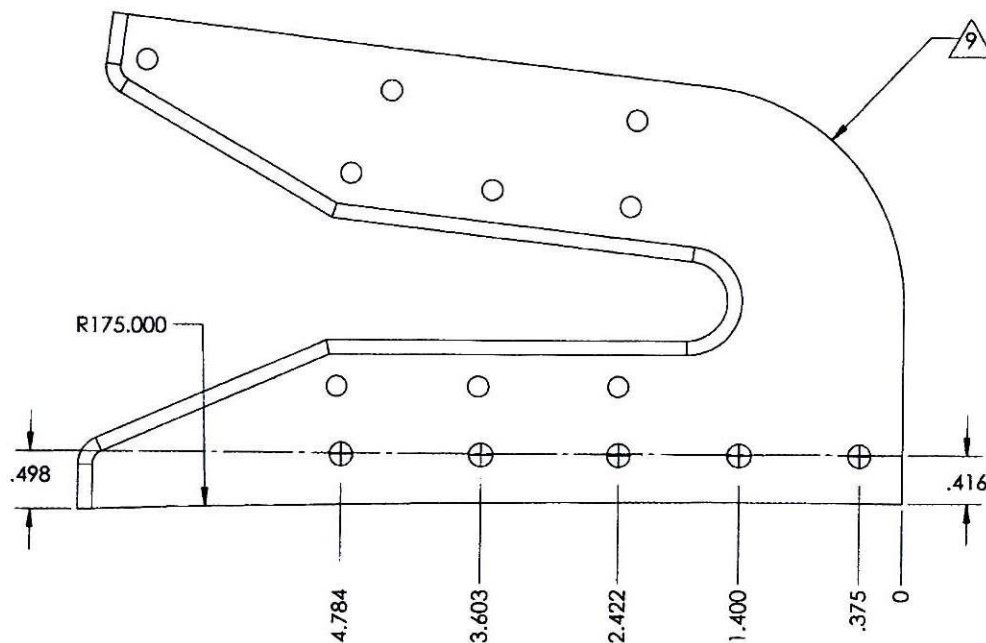
646.9712 $\triangle$ 9

ORIGINAL DATE 10/24/09		3030 ENTERPRISE CT., SUITE A	
DRAWN BY R. TOSANO		VISTA, CA 92081	
CHECKED BY P. BRAYO		(760) 724-5300	
DRAWING APPROVAL P. BRAYO		APICAL INDUSTRIES INC. DBA DART AEROSPACE	
DATE 05/29/09		CUTTER SUB ASSEMBLY	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SRT B	REV D
SCALE NONE		CAGE CODE 07MM6	DWG. NO. 646.9700
		SHEET 6 OF 7	

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646.9713



ORIGINAL DATE: 03-29-09		3030 ENTERPRISE CT.	
DRAWN BY: J. KRECHER		SUITE A	
P. POSANO		VISTA, CA. 92081	
DRAWING APPROVAL: J. BRAVO		(760) 724-5300	
CONTRACT NO.		APICAL INDUSTRIES INC.	
		DBA DART AEROSPACE	
CUTTER SUB ASSEMBLY			
SET: B	CAGE CODE: 07M26	DWG. NO: 646.9700	REV: D
SCALE: NONE		SHEET: 7 OF 7	